

Work Order ID 119335

119335

Page 1

Thursday, May 15, 2014 3:37:23 PM

Item ID: D3489-3-200 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Pip Pin
Start Date: 5/15/14 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 5/15/14 Req'd Qty: 10.00 *10* Customer:
Reference:

Approvals: Process Plan: MCS Date: 1405-20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3489	Rev A

100 PURCHASING 0.00
100
Purchasing Memo 0.00
Purchasing Issue P/O: 24327 P/N: 806206 Possible Supplier: Jergens
C214/05/23 10

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
Packaging Memo 0.00
Packaging Ensure material certification is attached
10x 14-5-29 8P

120 QC6- Inspect dimensions to drawing 0.00
120
QC Memo 0.00
Quality Control
4/5/29 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Work Order ID 119335***119335***

Thursday, May 15, 2014 3:37:23 PM

Item ID: D3489-3-200

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Pip Pin

Start Date: 5/15/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 10.00

10

Customer:

Reference:

Run

Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: GA

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

10X DAS MAY 30 2014
28
9-89

MLJ 14-05-02

14-05-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3489	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE PIP PIN	SCALE NTS
A	06.01.04	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

1) SPECIFICATION: **D3489-X-YYY PIP PIN**

WHERE 'X' IS THE NOMINAL SIZE IN 1/16THS OF AN INCH
AND 'YYY' IS THE GRIP LENGTH IN TENTHS OF INCHES

FOR EXAMPLE, D3489-3-050 IS 3/16" NOMINAL O.D. WITH 0.50" GRIP

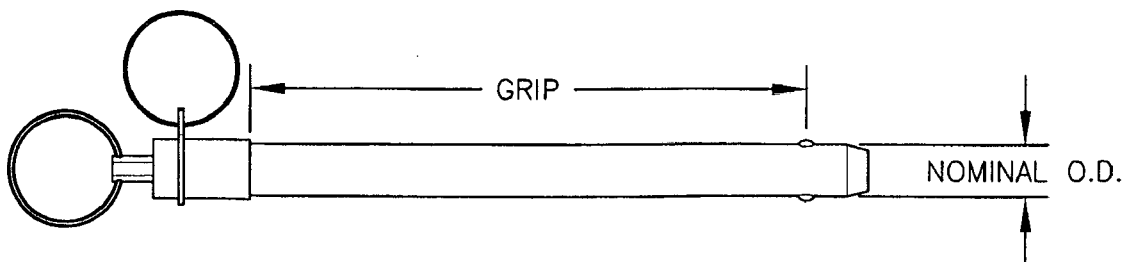
2) ACCEPTABLE SUPPLIERS / PART NUMBERS TO PURCHASE

DART P/N	Nominal O.D.	GRIP	Possible Suppliers	
			JERGENS	REID
D3489-3-050	3/16"	0.50	806200	DARS-000D
D3489-3-075	3/16"	0.75	806201	-
D3489-3-100	3/16"	1.00	806202	DARS-001
D3489-3-125	3/16"	1.25	806203	-
D3489-3-150	3/16"	1.50	806204	-
D3489-3-175	3/16"	1.75	806205	-
D3489-3-200	3/16"	2.00	806206	DARS-004
D3489-3-250	3/16"	2.50	806208	DARS-005
D3489-3-300	3/16"	3.00	806209	-
D3489-4-050	1/4"	0.50	806216	DARS-009
D3489-4-075	1/4"	0.75	806217	-
D3489-4-100	1/4"	1.00	806218	-
D3489-4-125	1/4"	1.25	806219	-
D3489-4-150	1/4"	1.50	806220	DARS-020
D3489-4-175	1/4"	1.75	806221	-
D3489-4-200	1/4"	2.00	806222	DARS-030
D3489-4-250	1/4"	2.50	806224	DARS-035
D3489-4-300	1/4"	3.00	806225	DARS-040
D3489-4-400	1/4"	4.00	808227	DARS-050

3) DESCRIPTION: DOUBLE ACTING, STAINLESS STEEL, QUICK-RELEASE
BALL LOCK PINS WITH RING HANDLE

4) MATERIAL: STAINLESS STEEL. MIN. PULL OUT STRENGTH = 200LBS (3/16" PINS)
OR 230LBS (1/4" PINS). MIN. DOUBLE SHEAR = 5150LBS (3/16" PINS) OR
9200LBS (1/4" PINS).

5) ALL DIMENSIONS ARE IN INCHES



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RELEASED
06-03-21 16

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119335 MJS
14-08-20



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24327

Purchase Order Date 5/23/2014

PO Print Date 5/26/2014

Page Number 1 of 3

Order From :

VC-HAS001

Ship To : DART AEROSPACE LTD

HASKINS INDUSTRIAL
5-52 ANTARES DRIVE
NEPEAN, ON K2E 7Z1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone

613 723 8800

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

Dicom

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	806206	PIP PIN	5/28/2014 Yes 5/28/2014		10.00 ✓ Each	\$22.82	\$228.2
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AS PER DWG D3489 REV. A
B119335
PROCUREMENT QUALITY CLAUSES
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A025 CERTIFICATE OF CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$228.2

2	71500-30	OFPT53AFEN4GB KC725M INSERT	5/28/2014 Yes 5/28/2014		30.00 ✓ Each	\$11.34	\$340.2
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14-5-29.

Line Total: \$340.2

Deliver To: CNC

Note:

5/26/2014

HASKINS INDUSTRIAL INC.
5-52 ANTARES DRIVE

** PACKING SLIP **

Order # 1253722

NEPEAN, ONTARIO K2E 7Z1
TEL (613)723-8800 FAX (613)723-8806

Order Date 05/26/14

Page 1 c

Sold To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

Ship To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

* Reprint

Cust Phone #		Warehouse		F.O.B.		Taken By	
		OTTAWA		DEST		Sylvie 613-723-	
Cust #	Customer P/O #	Required	Orig Order	Slsm	Ship Via	Terms	
05168	24327	05/27/14	1253722.00	PL	DICOM	NET 30	
Ln#	Bin #	Order UM	Ship	B/O	Product	Description	
1	CB1130	✓ 10 EA	10 ✓		PTD-0571651 0571651	A012 #41 JOBBER	DRILL TIN (
2	CB1120	✓ 10 EA	10 ✓		PTD-0571392 0571392	A012 #18 JOBBER	DRILL TIN (
3	CB1200	✓ 10 EA	10 ✓		PTD-0571231 0571231	A012 'H' JOBBER	DRILL TIN (
4		1 EA	0	1	3M1X1 7000148141	20317 ORBITAL SANDER	
5		✓ 30 EA	30 ✓		KEO1X1 2453684	OFPT53AFEN4GB KC725M INSERT	
6	CB1170	60 EA	60 ✓		PTD-0571897 0571897	A012 1/8 JOBBER	DRILL TIN (
7	030220	10 EA	10 ✓		DAS 27 JG-806206 14/5/29	3/16 DBL ACTION RING HANDLE	806:

PLEASE NOTE:

1. NO RETURNS WITHOUT PRIOR AUTHORIZATION
 2. ALL SHORTAGE CLAIMS MUST BE WITHIN 10 DAYS
 3. BO CODE: BO = QTY NOT SHIPPED IS BACK-ORDERED
- CL= QTY NOT SHIPPED WAS CANCELLED
SC= ITEM CONSIDERED COMPLETE - NO B/O CREATED

FILL PACK DATE 5/26/14
Printed on 2014-05-28 at 9:46